

Work Order ID 62397

Wednesday, September 29, 2010 1:26:09 PM



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Item ID:	D2435	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bearpaw, 206					
Start Date:	9/29/2010	Start Qty:	4.00			
Required Date:	10/21/2010	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:		Date:	10-9-27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2435	Rev E1								
120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT BLANK AS PER FILE D2435								
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435 3-Deburr								
140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B 10-10-4 (4)

M.A 10/10/05

4 0

M.A 10/10/05

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC8- Inspect parts - second check	0.00				4	0		
QC Quality Control	Memo	0.00							
151 	Identify as per dwg & Stock Location:	0.00							
Packaging Packaging	Memo	0.00							
190 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

SN 10/10/08

POD 6/6/23

10/10/12 (4)

10/10/12
MF
10-10-12

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Picklist Print

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Work Order ID: 62397



Parent Item: D2435



Parent Item Name: Bearpaw, 206

Start Date: 9/29/2010

Required Date: 10/21/2010

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

295.3533

3.2

12.8



UHMW 1" Black

12-10-4

Location

Loc Qty

Loc Code

MAT

295.3533

113903

79.7473

114624

8.8

115325

206.806

115325

④

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DART AEROSPACE LTD		Work Order:	62397
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435		Rev: E1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060 x 45°	✓		Vern	GA-01
B	5.500	+/-0.030	5.507	✓		"	"
C	0.200	+/-0.030	0.197	✓		"	"
D	R0.250	+/-0.030	R0.250	✓		Rad Gage	ref
E	0.250	+/-0.010	0.249	✓		Vern	GA-01
F	0.625	+/-0.030	0.630	✓		"	"
G	0.25 x 45°	+/-0.030	0.260 x 45°	✓		"	"
H	0.375	+/-0.010	0.377	✓		"	"
I	19.000	+/-0.030	19.000	✓		Tape	GA-12
J	0.950	+0.030/-0.010	0.958	✓		VERN	GA-01
K	Ø0.260	+0.005/-0.000	Ø0.260	✓		"	"
L	Ø0.930	+/-0.030	Ø0.925	✓		"	"
M	0.30	+0.030/-0.000	0.305	✓		Depth Gage	GA-08
N	0.375	+/-0.030	0.382	✓		Vern	GA-01
O	7.375	+/-0.030	7.375	✓		Vern	CNC-02
P	4.250	+/-0.010	4.250	✓		Vern	GA-01
Q	2.000	+/-0.030	2.006	✓		"	"
R	9.000	+/-0.010	9.000	✓		Vern	CNC-02
S	15.750	+/-0.030	15.750	✓		Tape	GA-12

Measured by:	HA	Audited by:	CA	Prototype Approval:	N/A
Date:	10/10/05	Date:	10/10/06	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF #	#

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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

RELEASED
98.06.17 KE

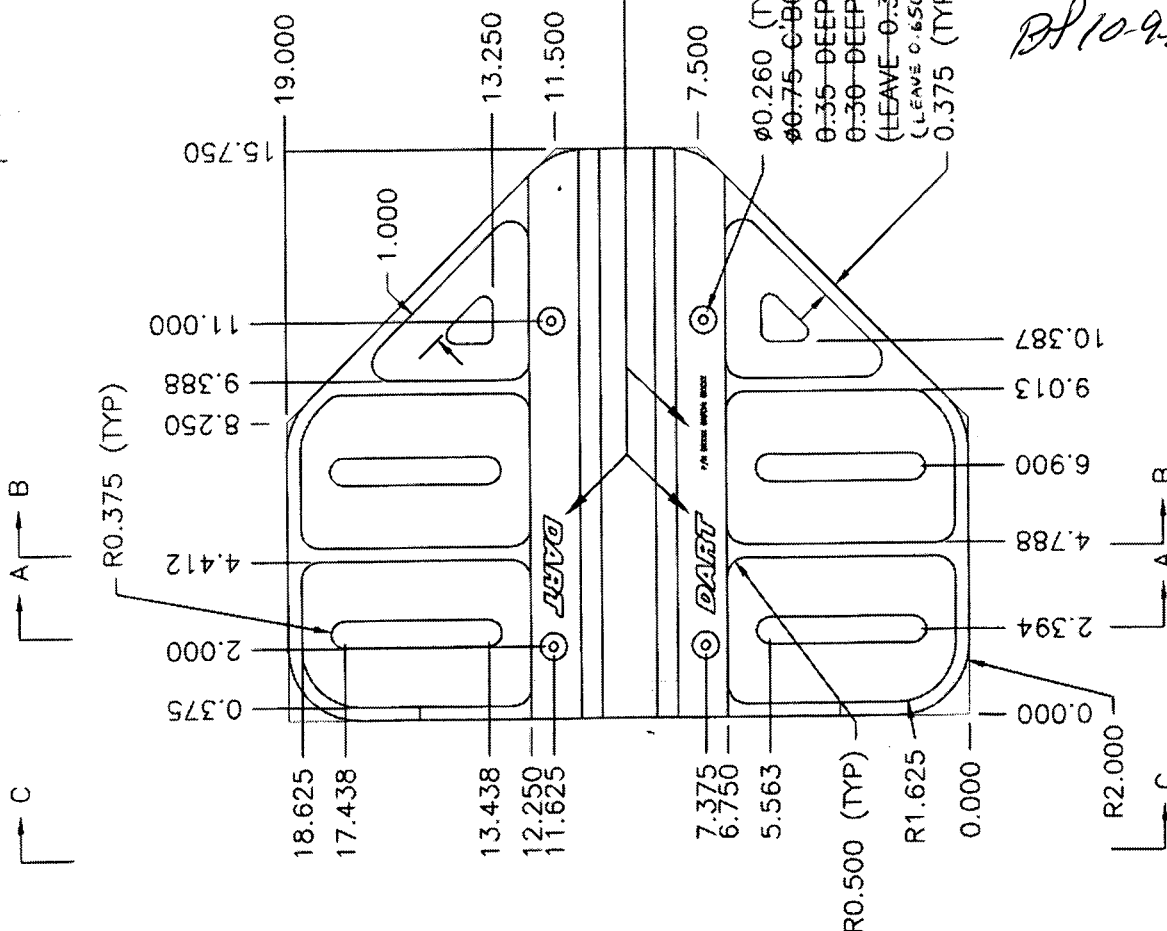
ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

EFFECTIVE DEOS

9143	
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *42397*

DS10-9-27



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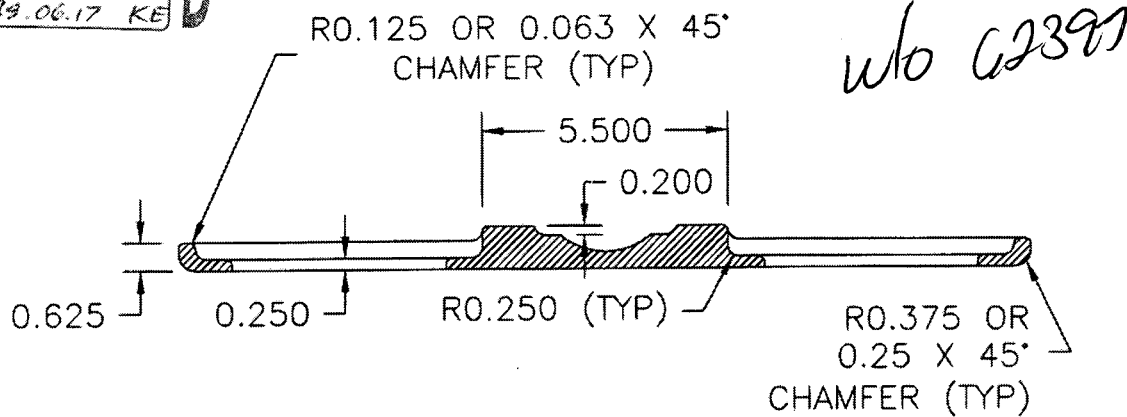
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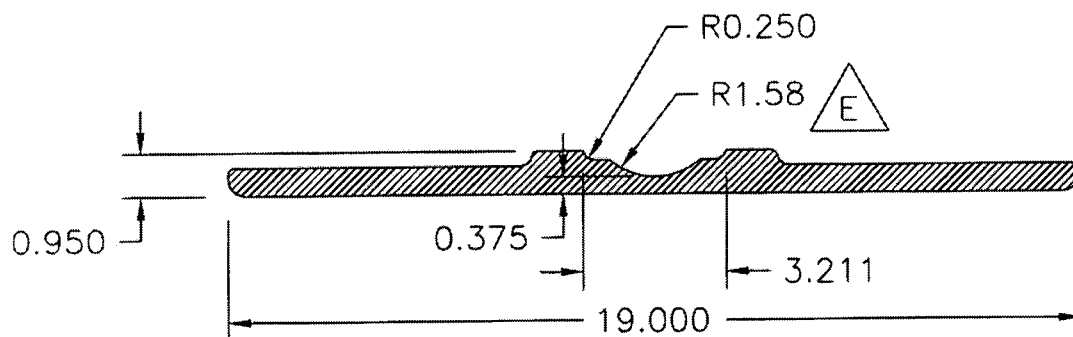


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

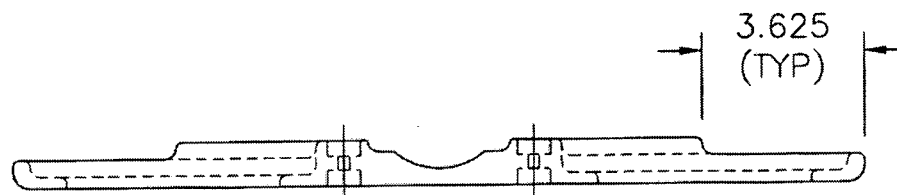
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
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